Date:

Tuesday, 12/5/2006 8:14:12 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29768

Estimate Number P.O. Number

: 10532

ALG.

This Issue

: 12/5/2006 : NC

Prsht Rev. First Issue

Previous Run

: nun : 29683

Type

: SMALL /MED FAB

Part Number

Drawing Number

Drawing Name

Project Number

Drawing Revision

Material **Due Date**

: SADDLE KIT

: K10003

: K10003

: 1/6/2007

: N/A

Qty:

12 Um:

Each

Written By

Checked & Approved By

Comment

: Est:

S.O. No. : N)A

Reformat: Incorporated D205-641-011

KJ/RF

Est: J 06-07-25

JLM

Est: K 06.11.17

Per K10003 Rev C

As per DSI 9344

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

DOCUMENT CONTROL

DC 1.0



Photocopy bluefile and type labels for D205-634-011 and D204-635-011 per PPP K10003

CHG005

NIV.

2.0

D2570



Comment: Qty.:

24.0000 Each(s)/Unit Total: 288.0000 Each(s)

Bushing



Qty 24

Part Number D2570

Description Bushing

3.0

D2571



Comment: Qtv.:

1.0000 Each(s)/Unit Saddle, Fwd, Out

Part Number

Description

Total:

12.0000 Each(s)

Pick:

Qty

1

D2571

Saddle

3 B2877860 B279

Page 1

Form: rprocess

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		W	ORK ORDER CHAN	IGES					-,
STEP	PROCEDURE CHANGE			E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1								
-	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ	A:	_ Date: _	
				C	QA: N/0	Close	d:	_ Date: _	
		WORK ORD	ER NON-CONFOR	MANCE (NCR)	-			
	Description of NC		Corrective Action S			Verifi	cation	Annroval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng					Chief Eng	QC Inspector
							:		
		^							
	TEP	TED PRO	TEP PROCEDURE CHA	WORK ORDER CHANTEP PROCEDURE CHANGE PAR #: Fault Category: WORK ORDER NON-CONFORITEP Description of NC	WORK ORDER CHANGES TEP PROCEDURE CHANGE PAR #: Fault Category: NCR: WORK ORDER NON-CONFORMANCE (INTERPRETATION OF NC Section A Section B Initial Action Description Section B Initial Initi	WORK ORDER CHANGES TEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes N QA: N/C WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ QA: N/C Close WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC Corrective Action Section B Section B Section A Section A Section Description Sign & Section B	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC Section A Section B Section C Section C Section C Section C Section C Chief Eng Prod Mgr

Date: Tuesday, 12/5/2006 8:14:12 AM Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Job Number: 29768 Part Number: K10003 Job Number: Description: Seq. #: Machine Or Operation: Saddle, Fwd, In 4.0 D2572 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: B 29661 Saddle, Fwd, in Pick: Part Number Description Qty Saddle D2572 1 D2573 5.0 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: Saddle, Aft, Out Pick: Description Qty Part Number D2573 Saddle 1 D2574 6.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Saddle, Aft, In Pick: 29513 (9x)+/B27059 Description Qty Part Number Saddle 1 D2574 D27361 7.0 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: Lug Assembly Pick: Qty Part Number Description Bracket D2736-1 1 D27363 8.0 Total: Comment: Qty.: 1.0000 Each(s)/Unit 12.0000 Each(s) Lug Assembly Pick: Qty Description Part Number D2736-3 Bracket 1

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W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
			QA:	N/C Close	d:	Date: _	
NCR:		WORK ORDER NON-CONFO	DRMANCE (NC	R)			
	1	Corrective Action	Section B				1

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
******		Description of NC	:	Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
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Date: Tuesday, 12/5/2006 8:14:13 AM Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Job Number: 29768 Part Number: K10003 Job Number: Seq. #: Description: Machine Or Operation: Set Screw 9.0 D2747 4.0000 Each(s)/Unit Total: 48.0000 Each(s) Comment: Qty.: Set Screw Pick: Qty Part Number Description Socket Head Set Screw 4 D2747 Saddle Spacer D2876 10.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s) Saddle Spacer Pick: Description Qty Part Number 2 D2876 Spacer D2877 11.0 2.0000 Each(s)/Unit Total: 24.0000 Each(s) Comment: Qty.: Saddle Spacer Pick: Part Number Description Qty 2 D2877 Spacer D2968041 12.0 . Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Tow Ring Pick: Description Qty Part Number D2968-041 Tow Ring 1 13.0 D35331 2.0000 Each(s)/Unit Total: 24.0000 Each(s) Comment: Qty.: Set Screw Batch: <u>B 28093</u> L

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W/O:		WORK ORDER C	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					
•			QA:	N/C Close	d:	Date:					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Ammerical	Annanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Date: Tuesday, 12/5/2006 8:14:13 AM Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 29768 Job Number: Description: Seq. #: Machine Or Operation: Bolt 14.0 AN46A Comment: Qty.: Total: 192.0000 Each(s) 16.0000 Each(s)/Unit Bolt Pick: Part Number Description Qtv AN4-6A Bolt 16 Bolt 15.0 AN446A Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s) Bolt Pick: Description Batch Part Number Qty M1021141 Bolt 4 AN4-46A AN451A 16.0 Comment: Qty.: Total: 96.0000 Each(s) 8.0000 Each(s)/Unit Bolt Pick: Part Number Description Qtv H102536V 8 AN4-51A Bolt 17.0 AN612A Bolt Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 8 AN6-12A Bolt AN960JD416 18.0 Total: 384.0000 Each(s) Comment: Qty.: 32.0000 Each(s)/Unit Washer Pick: Baylas (3) Batch Description Qty Part Number 1101938 32 AN960JD416 Washer

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>○↑/○1/∂</u> 7
, exc.			QA: N/C Closed:	Date:

	·	WORK OR	DER NON-CONFORMANC	E (NCR)			
	Description of NC	Corrective Action Section B			Varification	A	Approval
STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Section C		
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Portion Section B Section B Verification Approval Chief English

Date: Tuesday, 12/5/2006 8:14:13 AM Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 29768 Job Number: Description: Seq. #: **Machine Or Operation:** Washer 19.0 AN960JD616 Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s) Washer Pick: Qty Description Batch Part Number Washer 8 AN960JD616 AN9704 20.0 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: Washer Pick: Batch Description Part Number Qtv M 1023801 Washer AN970-4 MS21042L4 21.0 29.0000 Each(s)/Unit Total: 348.0000 Each(s) Comment: Qty.: Nut Pick: Description Batch Qty Part Number Nut (or MS21042-4) 29 MS21042L4 INSPECT 100% KITS FOR COMPLETE QC4 22.0 Comment: INSPECT KITS 100% FOR COMPLETENESS 23.0 PACKAGING 1 PACKAGING RESOURCE Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 24.0 Comment: FINAL INSPECTION/W/O RELEASE u 201.26 Job Completion

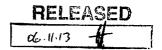
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W/O:		WORK ORDER (CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
			QA:	N/C Close	d:	Date: _	

NCR:			WORK ORDE	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B			A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
ı	CHECKED APPROVED		APPROVED,	DRAWING NO.	REV. C				
I	f	H .		K10003	SHEET 1 OF 1				
	DATE		V-3	TITLE	SCALE				
	06.1	1.07		SADDLE KIT	NTS				
	Α		00.06.01	NEW ISSUE					
	В		00.11.22	ADD D2707-041 OPTION					
	С		06.11.07	ADD D3533-1					



THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION	
BELL 205/210/212/412	D205-634-011	
	D205-634-015	
BELL 204	D204-635-011	

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16 STIOP COPY
AN6-12A	8	8	O היינו ווייים ס
AN960JD416	32	32	
AN960JD616	8	8	l 8 ortEn(.U)
*AN960JD1016	1	11	
AN970-4	1	1	I anthous Messe
MS21042-4 (OR L4)	25	25	25 WORK OF DER
* RE(QUIRED WITH D2	707-041 ONLY	NO:79768

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